

Date: Thursday, 6/29/2006 3:52:43 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : CLEVIS |
| Job Number | : 27798 | | |
| Estimate Number | : 10574 | | |
| P.O. Number | : N/A | Part Number | : D34531 |
| This Issue | : 6/29/2006 S.O. No. : N/A | Drawing Number | : D3453 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 27701 | Material | : N/A |
| Written By | : <u>SEE COMMENT BELOW</u> | Due Date | : 7/12/2006 |
| Checked & Approved By | : <u>06/06/29</u> | Qty: | 4 Um: Each |
| Comment | : A 05.09.27 New issue EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|-----------|
| 1.0 | M304R1250 | Inventory |
|-----|-----------|-----------|



Comment: Qty.: 0.2880 f(s)/Unit Total : 1.1520 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: M101549

06/07/18

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA577 Rev: — & Dwg D3453 Rev: —

N/A Machined Manually

2- Deburr as per dwg D3453

06/07/18

| | | |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/18

| | | |
|-----|-------|--------------------------------|
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1-Mill as per Folio FA577 Rev: — & Dwg D3453 Rev: —

N/A Machined Manually

2- Deburr as per dwg 3453

06/07/18

| | | |
|-----|-----|----------------------------------------|
| 5.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/07/24

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 3:52:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27798

Part Number: D34531

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

PD 06/07/18 4

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

PD 06/07/18 4

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/18 x4

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W11*

PD 06-07-18 4

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

106.07.20

Job Completion



W 06/07/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

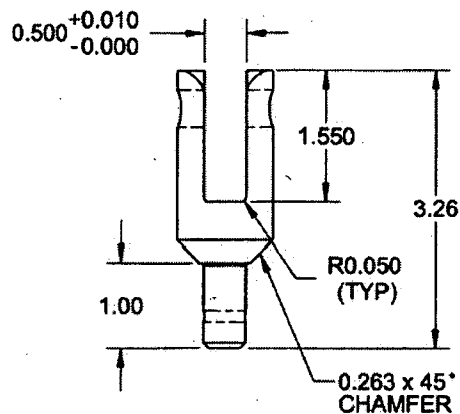
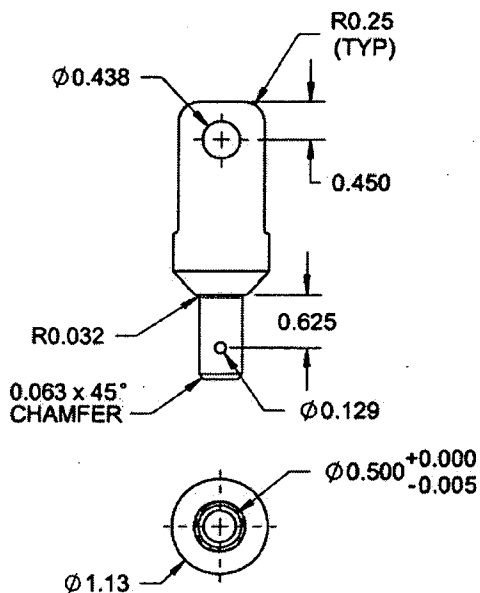
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

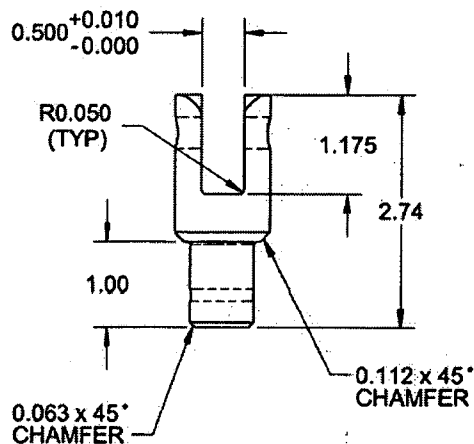
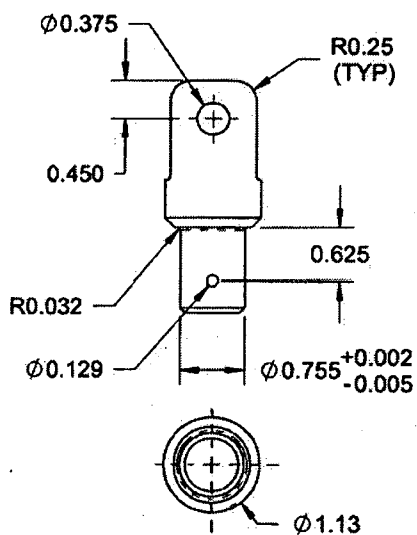
QA: N/C Closed: _____ Date: _____

DART

| | | | |
|-------------------------|------------------------|----------------------------------------------------------|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3453 | REV. A SHEET 1 OF 2 |
| DATE 05.09.02 | TITLE CLEVIS | | SCALE 1:2 |
| A | 05.09.02 | NEW ISSUE | |

**D3453-1 CLEVIS****RELEASED**

05.12.09

**D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

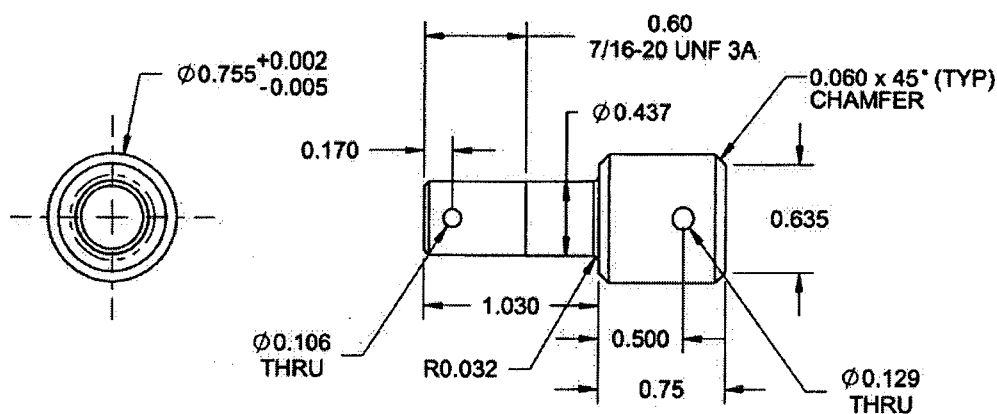
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DART

| | | | |
|-------------------------------|--------------------------------|----------------------------------------------------------|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3453 | REV. A SHEET 2 OF 2 |
| DATE 05.09.02 | TITLE CLEVIS | | SCALE 1:1 |

RELEASED05.12.09 *[Signature]***D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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